

Date: Monday, 5/7/2007 7:35:28 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B STEP ASSEMBLY RH
Job Number	: 26714		
Estimate Number	: 11115		
P.O. Number	: <i>N/A</i>	Part Number	: D206628012
This Issue	: 5/7/2007	Drawing Number	: <i>N/A</i>
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i>	Drawing Revision	: <i>N/A</i>
Previous Run	: 25447	Material	: <i>N</i>
		Due Date	: 5/10/2006
Written By	: <i>[Signature]</i>	Qty:	3 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: <i>D</i> As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-012 CHG 002

2.0	26714A	206B STEP ASSY, RH
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Comment: Sub-Component D2721-042 SUB-ASSEMBLY

206B STEP ASSY, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27311	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2731-1	Mounting Lug	<i>139112</i>
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*RE-worked on who 33892. NCR 192 should be 02731-3*

5.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2731-7	Mounting Lug	<i>1330996</i>
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*7/2/2 SQ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 7:35:28 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 26714

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty Part # Description

2 D2856-400 6.9" Abrasion Strip

Batch

1332020

X

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.6380 f(s)

Pick :

Qty Part # Description

2 D2856-400 6.25" Abrasion Strip

Batch

1332020

X

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

2 D3394-041 LUG ASS,Y

Batch

1330997

X

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

2 D3394-043 LUG ASS,Y

Batch

1330998

X

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description

4 AN4-15A Bolt

Batch

1104072

X

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description

4 AN4-11A Bolt

Batch

1102280

7/7/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/07/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 7:35:28 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 26714

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

M104291 X

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1

12 AN960JD416

Washer

M103691 X

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1

12 MS21042L4

Nut (or MS21042-4)

M102552 V

7/7/259

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/7/06

(3) C207107106(3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-012

Location:

PPP Rev:

Reve

7/7/6 59

7/7/06

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

7/7/06

Job Completion



U 07.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ship 04/07!!!

Date: Monday, 5/7/2007 7:35:41 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B STEP ASSY, RH
Job Number : 26714A	
Estimate Number : 11699	
P.O. Number : N/A	Part Number : D2721042
This Issue : 5/7/2007	Drawing Number : D2721 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 25447A	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 5/10/2006
Checked & Approved By : <u>[Signature] 07.05.07</u>	Qty: 3 Um: Each
Comment : Est Rev: As Per Ecn 766 06-01-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B 31984</u>

Check Material for any Dents or Defects

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-2 using D2622 extrusion as per Dwg D2721  
Deburr and bevel ends for welding

Q.m 07.06.28

Q.m 07.06.28

(3)

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>B30883</u>

[Signature] 07.06.28 3

4.0	D34611	PLATE
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

206 Step Lug

Pick:

Qty	Part Number	Description	Batch
1	D3461-1	Plate	<u>B29612</u>

[Signature] 07.06.28 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 5/7/2007 7:35:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 26714A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-3	Plate	<u>329611</u>

*KE. 07.06.28 3*

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-5	Plate	<u>329614</u>

*KE. 07.06.28 3*

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-7	Plate	<u>329616</u>

*KE. 07.06.28 3*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod

Batch: M108766  
M104721

*KE. 07.07.04 3*

Grind end cap welds flush

*A.M*

*07.07.04*

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*QC9 M07/07/04 3*  
*QC5 Sn 07/07/04 4.3 RH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 7:35:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 26714A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*A.M. 07.02.05*

3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PE. 07.07.05*

3

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

*PE. 07.07.05*

3

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

*PE. 07.07.05*

3

A/R AL Rod

Batch:

*M102756  
M104721*

*PE. 07.07.05*

3

Grind End Cap Welds Flush

*A.M. 07.07.05*

3

13.0

QC5/9

WELD INSPECTION



*QC #5 En 07/07/05*



Comment: WELD INSPECTION

*PD 07-07-05*

(3)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*M.L. 07/07/05*

(3X)

Touch Up Alodine

15.0

POWDER COATING

POWDER COATING



*M 104144*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/FZ.*

*07-07-05*

(3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PE 7/7/05 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/07/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 7:35:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 26714A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M104733



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

FL 07/07/05 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20705



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 26714 7/7/06 SD 07/07/06

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(3)  
07/07/06

Job Completion



U 07-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

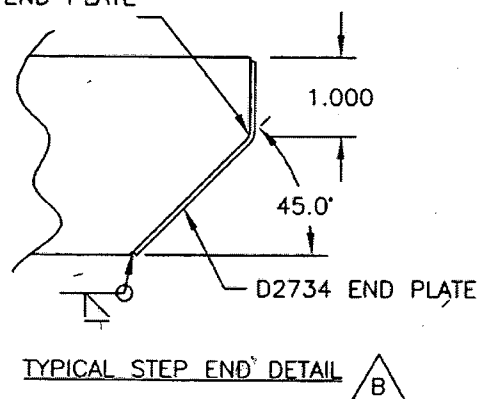
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
05.11.14 ~~76~~

DESIGN	PH	APPROVED	DRAWING NO.	REV. C
PH	PH		D2721	SHEET 1 OF 1
DATE	05.09.19	TITLE	SCALE	
		206B STEP ASSEMBLY	NTS	
A	97.12.04	NEW ISSUE		
B	98.10.19	79° WAS 80°. UPDATED WELD DETAIL. REVISED TOLERANCES, 53.44 WAS 54.0		
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7、		



QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTENSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

1) MAKE FROM EXTRUSION D2622

2) WELD PER DART QSI 004

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT,  
WITHOUT NOTICE  
WORK ORDER  
NO. 26714A

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